

**Work Order ID 66428**

Monday, February 14, 2011 12:55:17 PM



Page 1

Item ID: D3394-043

Revision ID:

Item Name: Lug Assembly

Start Date: 2/15/2011 Start Qty: 16.00

Required Date: 3/1/2011 Req'd Qty: 16.00

B/W

Accept



Setup Start



Stop



Reference:

Approvals: Process Plan: MF

Date: 11-02-14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3394 DEO	Rev B

100



BAND SAW

Bandsaw

Jespa Bandsaw

Memo

Cut Blank to .850"

0.00

0.00

120



HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA808  
FOLIO REV: \_\_\_\_\_  
DWG REV: \_\_\_\_\_

0.00

0.00

CD 11/02/14 16

Purchasing

DEBURR

issue Proto metec P/O: 13491

machines per day D 3394 REV.C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 66428**

Page 2

Monday, February 14, 2011 12:55:17 PM

*BL0*

Item ID: D3394-043

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 2/15/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 3/1/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



*QC read*  
Quality Control

QC2: inspect parts off machine FAI/FAIB

0.00

0.00

*5/16/09*

*14/3/16 (16)*

135



*QC*  
Quality Control

QC3: Inspect parts - second check

0.00

0.00

*(X16)*

140



*HandFinish*  
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

*16 BL 11-39*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 66428**

Monday, February 14, 2011 12:55:17 PM



Page 3

Item ID: D3394-043

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 2/15/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 3/1/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

155



Spray Painting per QSI005 4.2

0.00

*ml 4 03 10 P40*

SprayPaint

Memo

0.00

Spray Painting

Prime Delfleet Blue :B 115967  
Paint Delfleet Blue :B 115985  
Clear Delfleet :B 117113

165



QC14- Inspect Spray Paint

0.00

*Suloshie*

QC

Memo

0.00

Quality Control

170



Small Fab

0.00

*EP 11/03/21 16*

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3394

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3394-043 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 1103-28

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 66428		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-03-17	155	product line of defleet charging to lower loc's supplier misinformed + sent wrong clear	1103.18	scruff + re clear update QSR 005 P3118 + P3921 1 to 1 1 to 1 mixture 3 parts 1 part P3210 1/2 part P3330 ACCEPTABLE PER ATTACHED BMAIC.	ST 11-03-17	1103-18	1103.18 031042.	1103-18 031042.

NOTE: Date & initial all entries

**Work Order ID 66428**

Page 4

Monday, February 14, 2011 12:55:17 PM

Item ID: D3394-043

Accept



Setup

Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 2/15/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 3/1/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

180



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Su (03/21)

(x16)

190



Packaging

Packaging

Identify as per dwg & Stock Location: 420

0.00

0.00

11/3/21 SF 162

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

11/3/21 JJ

11/08/21

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Picklist Print

Monday, February 14, 2011 12:50:07 PM

Page 1

Work Order ID: 66428



**Parent Item:** D3394-043



**Parent Item Name:** Lug Assembly

**Start Date:** 2/15/2011

**Required Date:** 3/1/2011

Comments: IPP Rev: A New Issue 06-01-06 JLM

**Start Qty:** 16.00

Start Qty: 16.00

**Required Qty: 16.00**

**Required Qty: 16.00**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

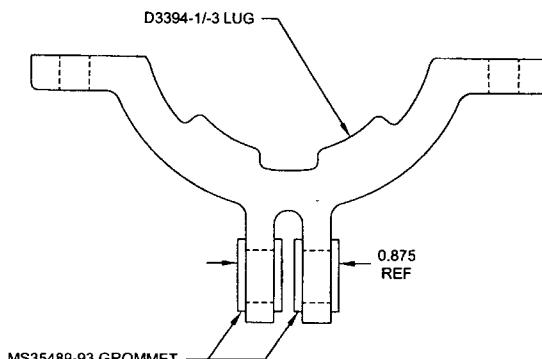
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

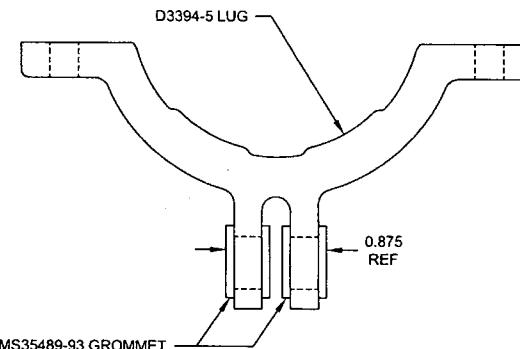
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
X			D3394-043	LUG ASSEMBLY
	X		D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
1			D3394-3	LUG
	1		D3394-5	LUG
2	2	2	MS35489-93	GROMMET



D3394-041/-043 LUG ASSEMBLY



D3394-045 LUG ASSEMBLY

X66488

DEO ATTACHED  
RELEASED  
09/06/25 ADW

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs APPROX

B	ADDED -045. SHT 4 ADDED FILLETS IN SECTION A-A- SEE PAR 152		AJS	09.04.02
A	NEW ISSUE		PH	05.02.14
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	B	DRAWING NO.	REV. B	
MFG. APPR.	91	D3394	SHEET 1 OF 4	
APPROVED	10	TITLE	SCALE	
DE APPR.		LUG	NTS	
DATE	09.04.02			

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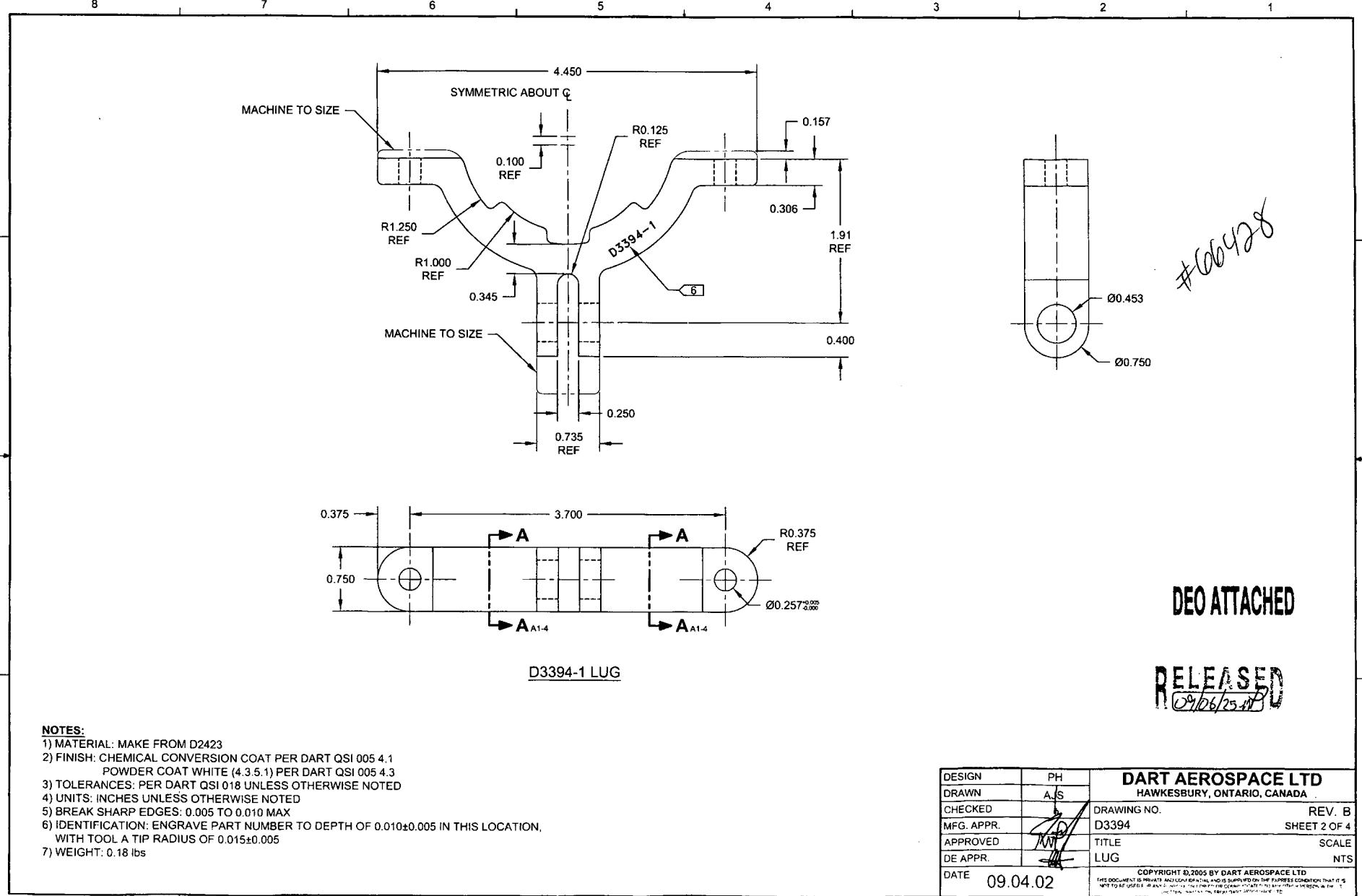
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**NOTES:**

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF  $0.010 \pm 0.005$  IN THIS LOCATION,  
WITH TOOL A TIP RADIUS OF  $0.015 \pm 0.005$
- 7) WEIGHT: 0.18 lbs

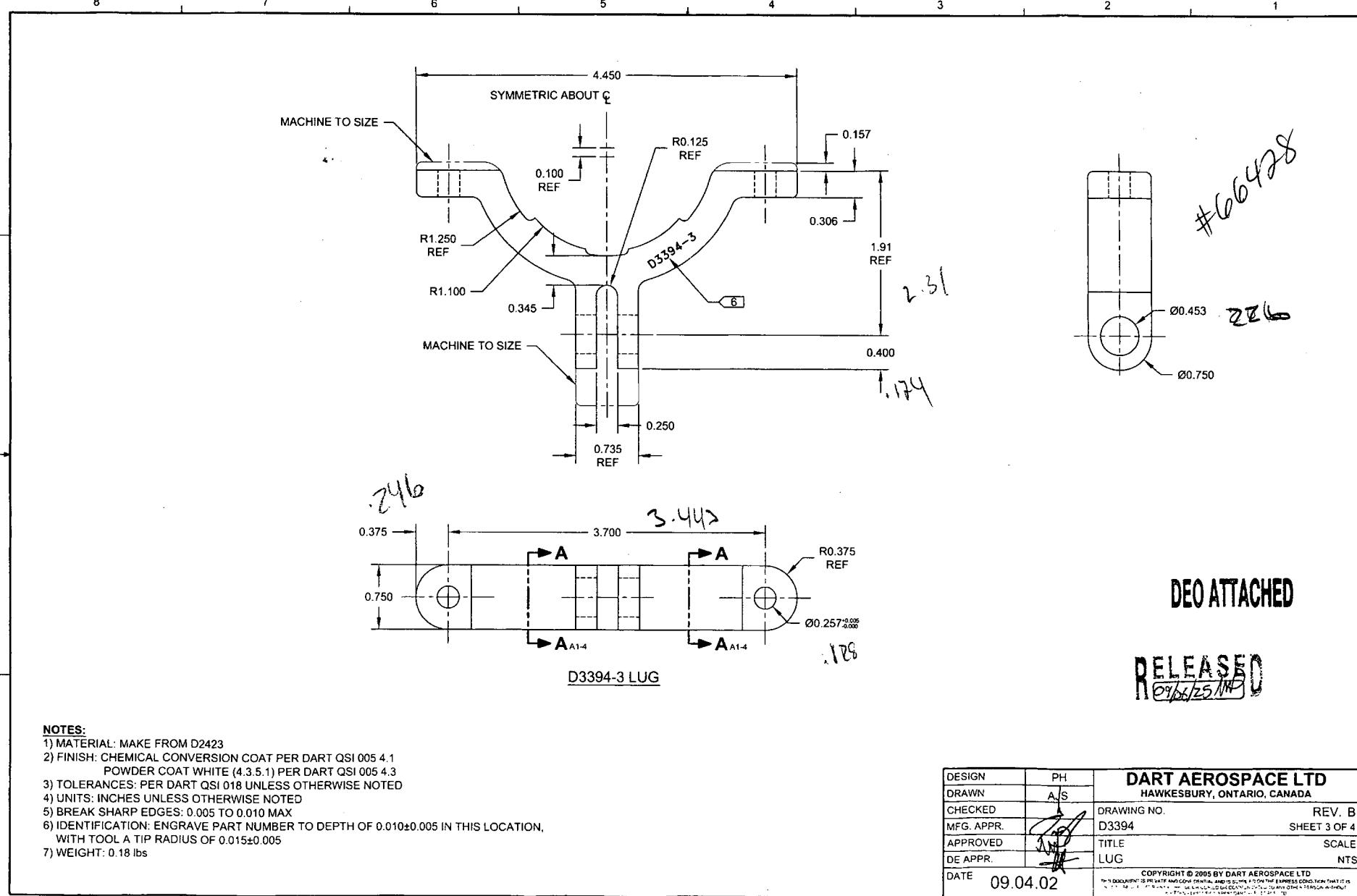
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	A.S			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.	<i>SAC</i>	D3394	SHEET 2 OF 4	
APPROVED	<i>NMT</i>	TITLE	SCALE	
DE APPR.	<i>SS</i>	LUG	NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	09.04.02		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

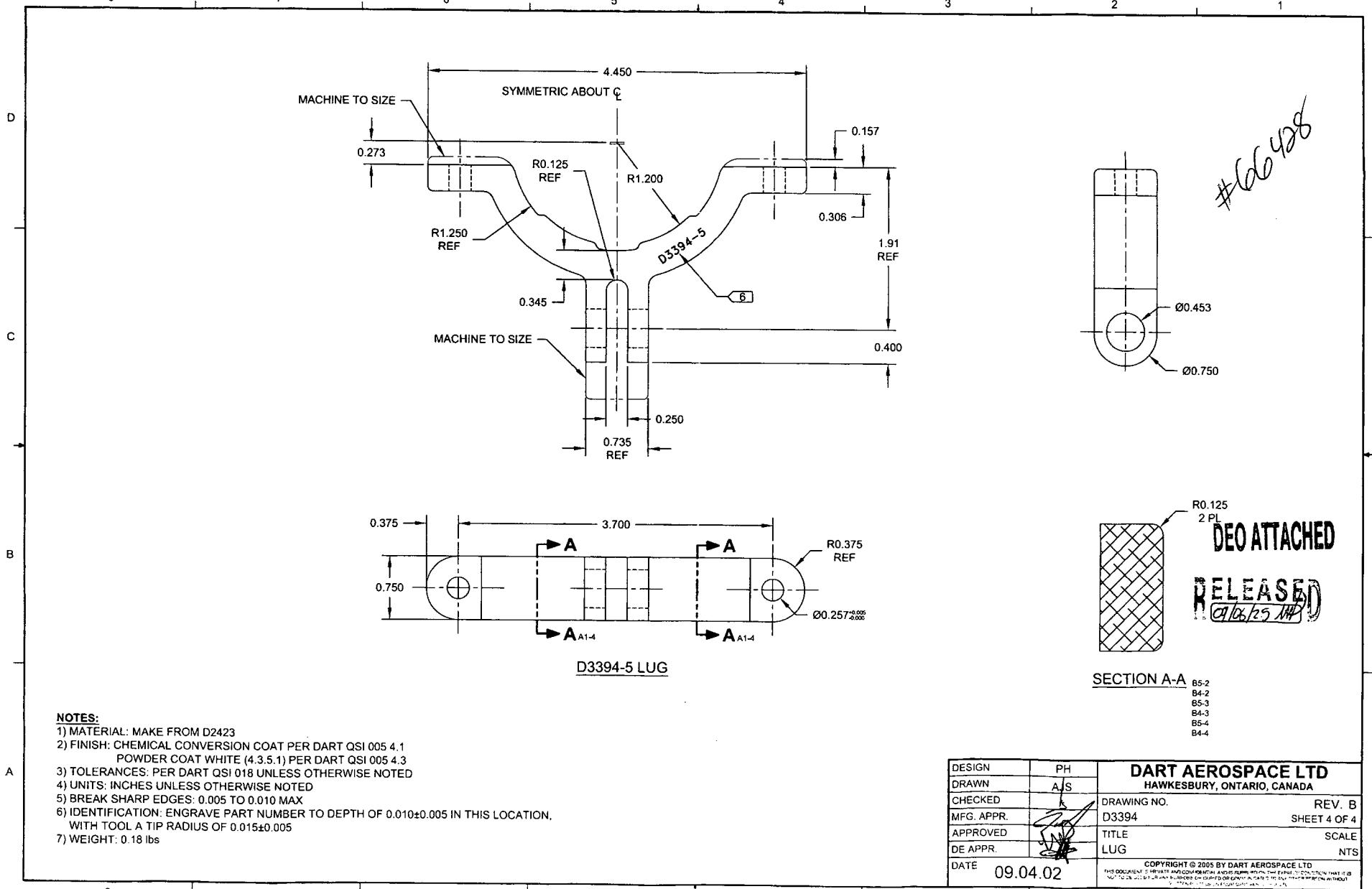
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	09.04.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS OWNED BY DART AEROSPACE LTD. IT IS NOT TO BE COPIED, REPRODUCED, OR DISCLOSED TO OTHERS OR USED FOR OTHER PURPOSES WITHOUT THE EXPRESS WRITTEN CONSENT OF DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

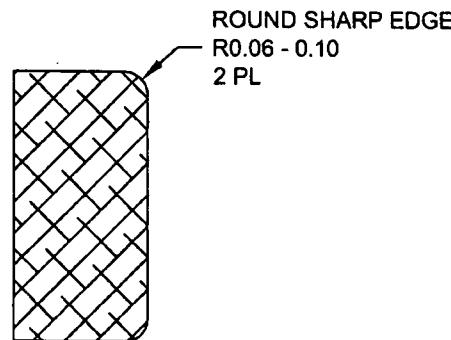
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3394-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED <i>WJ</i>	DE APPR. <i>WJ</i>		
DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	

SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

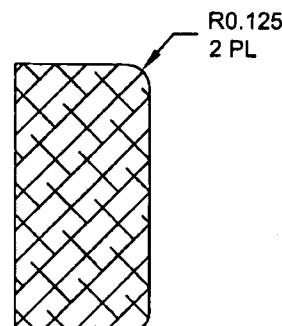
**IS:**



**SECTION A-A**

*#66418*

**WAS:**



**SECTION A-A**

**RELEASED**  
2009-11-25  
*WJ*

REASON: DRAFTING ERROR

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO13491

Purchase Order Date 2/14/11  
PO Print Date 2/14/11

Page Number 1 of 1

Order From : VC-MET003

METEC METAL TECHNOLOGY INC.  
20 TERRY FOX DRIVE PO BOX 781  
VANKLEEK HILL, QC K0B 1R0  
CA

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
*(Call 10/20/11)*

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2731-7P	LUG	2/25/11 Yes	50.00 Each		\$13.9000	\$695.00
			<b>Special Inst:</b>	MACHINE AS PER DWG D2731 REV. C B66427 PAINT WHITE X 34 B66419 PAINT DELFLEET BLUE X 16			
2	D3394-3P	Lug	2/25/11 Yes	50.00 Each	Dart Truck	\$18.9500	\$947.50
			<b>Special Inst:</b>	MACHINE AS PER DWG D3394 REV. B B66429 PAINT WHITE X 34 B66428 PAINT DELFLEET BLUE X 16	<i>16 + 34</i>		

PO Total: \$1,642.50



Change Nbr: 2

Change Date: 2/14/11

*CY*

No substitution or deviation without consent.  
Certificate of Conformity or Material Certification required when applicable



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 17817  
**Date:** Mar 09, 2011  
**Page:** 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13491	Sold By:
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 LUG Material supplied by DART: D2423 B63005	Each			
D3394-3 Lug Material supplied by DART: D2423 B63005	Each		50	16
<i>8 u/s 10/9</i>				
Received by _____	<b>Thank you for your order!</b>			



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D3394-3	Lug	13491

MATERIAL: supplied by DART D2423 B63005

Salosloz

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shigi Walz".

Shigi Walz

Vankleek Hill, March 9, 2011

## **Linda Lacelle**

---

**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** March 18, 2011 11:14 AM  
**To:** 'Marc Bellavance'; 'Linda Lacelle'  
**Subject:** RE: D206-642-441B Skidtubes

Linda/Marc,

I was concerned that we had discovered a chemical incompatability between the new paint and the clear and that is why we had to re-clear the skidtubes. Scuffing and re-clearing the skidtubes to a matte finish is acceptable to me.

David

**From:** Marc Bellavance [mailto:[mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)]  
**Sent:** Friday, March 18, 2011 9:04 AM  
**To:** 'Linda Lacelle'; 'Shepherd, David'  
**Subject:** RE: D206-642-441B Skidtubes

Linda, please call David, he has one or a few questions for you...

**From:** Linda Lacelle [mailto:[llacelle@dartaero.com](mailto:llacelle@dartaero.com)]  
**Sent:** March 18, 2011 9:32 AM  
**To:** 'Marc Bellavance'; 'Shepherd, David'  
**Subject:** RE: D206-642-441B Skidtubes

The skids were already scuffed, and the new clear was applied...these are suppose to ship today

**From:** Marc Bellavance [mailto:[mbellavance@dartaero.com](mailto:mbellavance@dartaero.com)]  
**Sent:** March 18, 2011 9:25 AM  
**To:** Shepherd, David  
**Cc:** Lacelle, Linda  
**Subject:** D206-642-441B Skidtubes  
**Importance:** High

Good morning David,

Ian came to see me this morning re Delfleet product line changing to lower VOC's. The supplier was misinformed and sent us the wrong clear. Now the skidtubes must be scuffed and re-cleared. Also, this will affect QSI 005 since the mixture must be changed. A W/O NCR has been filled out by Ian on all the W/O's ( but we need your approval on this prior to signing off them off.

Call me if you have more questions, I'll answer with what I have and know about this issue.

Thanks,

**Marc Bellavance**  
**Technical/Shop Support**